

# Work Order ID 53230

October 28, 2009 7:09:47 AM



Page 1

Item ID:	D3173-041	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Beam Assembly					
Start Date:	10/28/09	Start Qty:	2.00		Cust Item ID:	
Required Date:	10/30/09	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	Tooling:	Date:	Run	Start	
	QC:		Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3173	Rev B								
100	BAND SAW	0.00							
	Bandsaw								
Jeaspa Bandsaw	Memo	0.00							
	Cut blank: 56" long <input type="checkbox"/> Machine holes as per Folio FA295 and Dwg D3173 <input type="checkbox"/> Identify as D3173-1								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1								
HAAS CNC vertical machine #1	Memo	0.00							
	Machine holes as per Folio FA295 and Dwg D3173 Identify as D3173-1								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

pull D3173-1 from stock B 20356 SB 289/10/29

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Item ID: D3173-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Beam Assembly

Start Date: 10/28/09 Start Qty: 2.00



Cust Item ID:

Required Date: 10/30/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00							
140 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Drill Ø0.316" holes as per Dwg D3173 D3173 □3-deburr								
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							

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Item ID: D3173-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Beam Assembly

Start Date: 10/28/09 Start Qty: 2.00



Cust Item ID:

Required Date: 10/30/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

Ensure Nut Plate thread is covered.

1.75 OVEN TEMPERATURE: 320°

TIME: 1.45

START TIME:

FINISH

BR 09-11-2

②

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Item ID: D3173-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Beam Assembly

Start Date: 10/28/09 Start Qty: 2.00



Cust Item ID:

Required Date: 10/30/09 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

2) 8/9/10/12

(12)

/

200



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

Assemble per Dwg D3173. ☐ Install Mounting Lug as per Dwg D3173. D3175-041 is included in K10017 BOM.

E 509/10/03 (2)

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2) 8/9/10/13

(12)

/

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Item ID: D3173-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Beam Assembly

Start Date: 10/28/09 Start Qty: 2.00



Cust Item ID:

Required Date: 10/30/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

Identify as per dwg & Stock Location 201

0.00



Packaging

Memo

0.00

Packaging

09/11/03 (2)

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/04 MF

MF

09-10-04

# Picklist Print

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Work Order ID: 53230

Parent Item: D3173-041RevB

Parent Item Name: Beam Assembly

Start Date: 10/28/09

Required Date: 10/30/09

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN3-5A		Purchased	No			200	Each	2,247.000	16.0000			
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Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2247

100188

188

105057

2059

AN5-23A		Purchased	No			200	Each	23.0000	4.0000			
---------	--	-----------	----	--	--	-----	------	---------	--------	--	--	--



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

23

19278

23

*ES 09/11/03*

*16*  
*ES 09/11/03*

*4*

# Picklist Print

Page 2

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Work Order ID: 53230



Parent Item: D3173-041RevB



Parent Item Name: Beam Assembly


Start Date: 10/28/09

Required Date: 10/30/09

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10  Washer		Purchased	No			200	Each	1,736.000	16.0000			

*EP 09/11/03*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1736

105442

95

109059

2

109840

23

110985

202

111279

5

111668

64

112314

968

112369

377

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
*16*

# Picklist Print

October 28, 2009 7:09:45 AM

Work Order ID: 53230



Parent Item: D3173-041RevB



Parent Item Name: Beam Assembly

Start Date: 10/28/09

Required Date: 10/30/09

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516  Washer		Purchased	No			200	Each	1,565.000	8.0000			



*EP 09/11/03*

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
ST	1565	
100564	2	
106167	6	
107534	34	
107959	43	
108246	46	
108672	2	
109059	49	
109752	22	
110363	46	
110523	57	
111279	39	
112082	68	
112314	500	
112794	151	
112828	500	

D3173-1RevB

Manufactured No



Beam

Each

2.0000

2.0000



*EP 09/11/03*

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
ST	2	
20356	2	

*2*



# Picklist Print

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Work Order ID: 53230

Parent Item: D3173-041RevB

Parent Item Name: Beam Assembly

Comments:

Start Date: 10/28/09

Required Date: 10/30/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3175-041RevA      Manufactured      No



Mounting Lug

Warehouse      Loc Qty      Loc Code

Location

Main Warehouse

ST      6

25025      1

41678      5

D3178-041RevA      Manufactured      No



Nut Plate

170      Each      18.0000      4.0000

Warehouse      Loc Qty      Loc Code

Location

Main Warehouse

ST      18

24895      10

25298      8

MS20601-AD4W4      Purchased      No



Rivet

200      Each      47.0000      16.0000

Warehouse      Loc Qty      Loc Code

Location

Main Warehouse

ST      47

19278      47

*EP 09/11/03*

*4*  
*EP 09/11/03*

*EP 09/11/03*

*16*

# Picklist Print

October 28, 2009 7:09:46 AM

Work Order ID: 53230



Parent Item: D3173-041RevB



Parent Item Name: Beam Assembly

Start Date: 10/28/09

Required Date: 10/30/09

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L5  Nut		Purchased	No			100	Each	1,065.000	4.0000			



*EP 09/11/03*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1065

110382

10

111127

4

111636

51

112314

1000

\_\_\_\_\_  
\_\_\_\_\_  
*4*  
\_\_\_\_\_



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3173	REV. B SHEET 1 OF 3
DATE 03.01.07		TITLE BEAM ASSEMBLY	SCALE NTS
A	02.12.03	NEW ISSUE	
B	03.01.07	REMOVE PIP PINS	

*WU 53230*

## PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3173-041	BEAM ASSEMBLY
1	D3173-1	BEAM
2	D3175-041	MOUNTING LUG
2	D3178-041	NUT PLATE
8	AN960JD10	WASHER
4	AN960JD516	WASHER
2	MS21042L5	NUT
8	MS20601AD4W4	RIVET
8	AN3-5A	BOLT
2	AN5-23A	BOLT

## NOTES

### D3173-1 BEAM:

- 1) PART IS SYMMETRICAL ABOUT CENTERLINE
- 2) MATERIAL: 6061-T6 RECTANGULAR TUBING, 4" x 2" x 0.125" WALL (QQ-A-200/8)  
(REF DART SPEC. M6061T6TR4.0x2.0W125)
- 3) BREAK ALL SHARP EDGES 0.010-0.020
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 OUTSIDE ONLY
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

RELEASED  
03 01 20

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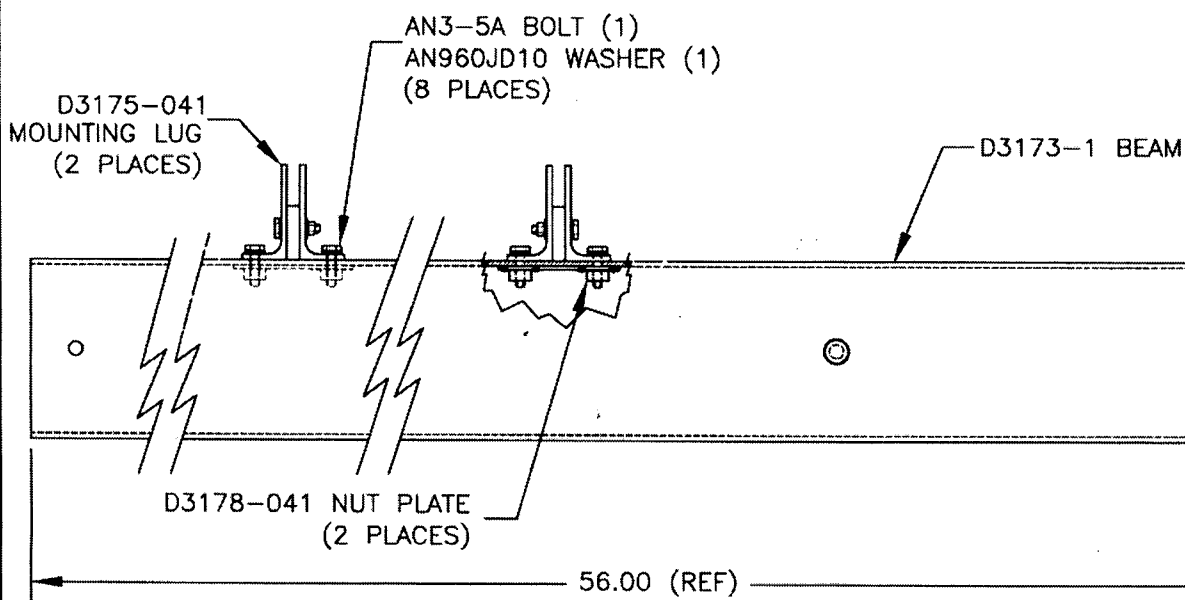
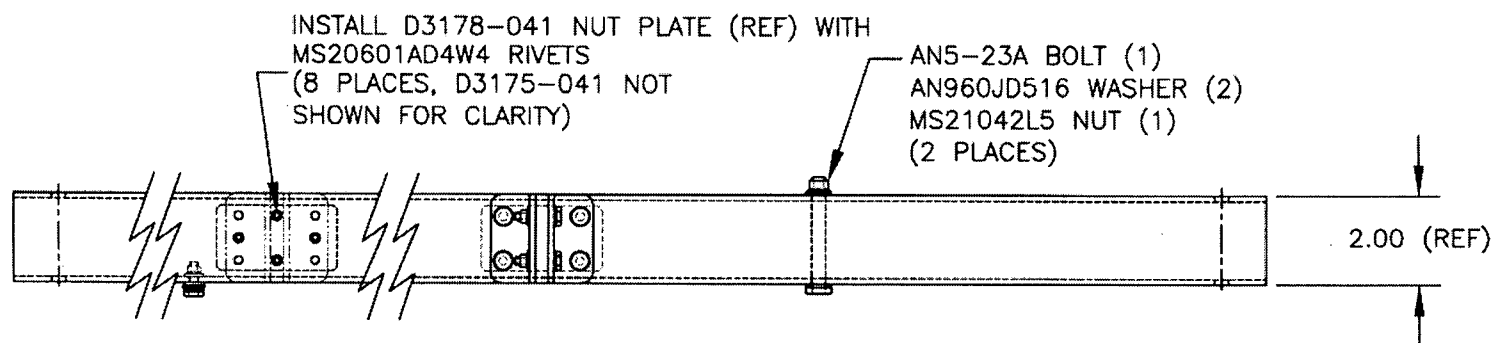
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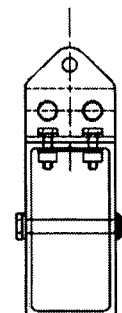
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CHECKED	APPROVED	DRAWING NO.	REV. B	
DATE		D3173	SHEET 2 OF 3	
03.01.07		TITLE	SCALE	
		BEAM ASSEMBLY	1:4	

W 033230



**D3173-041 BEAM ASSEMBLY**

RELEASED  
03.01.07



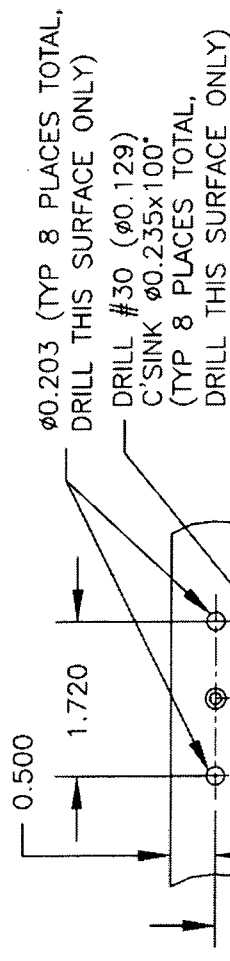
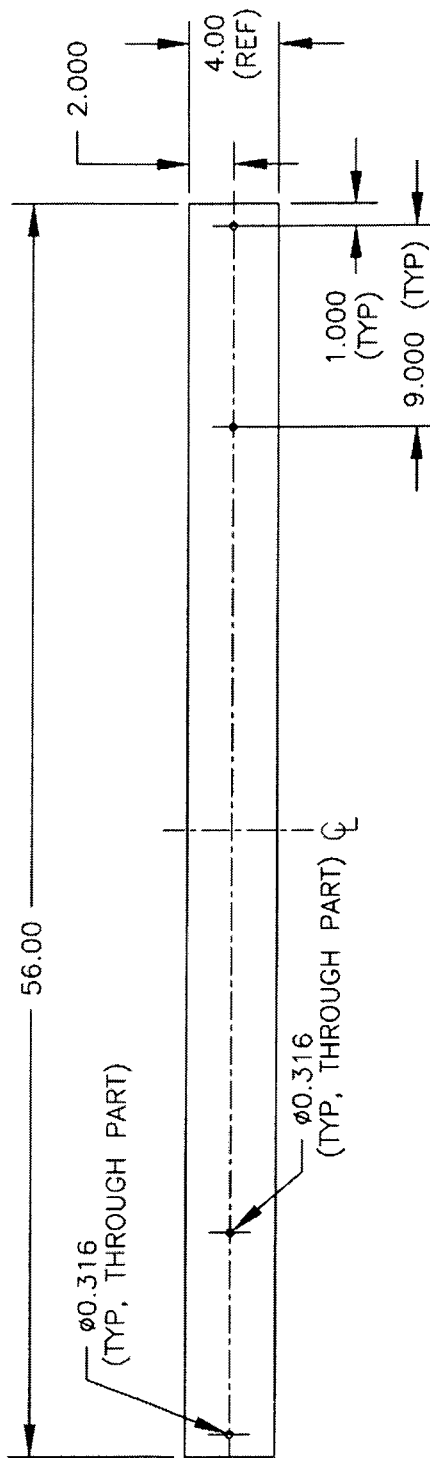
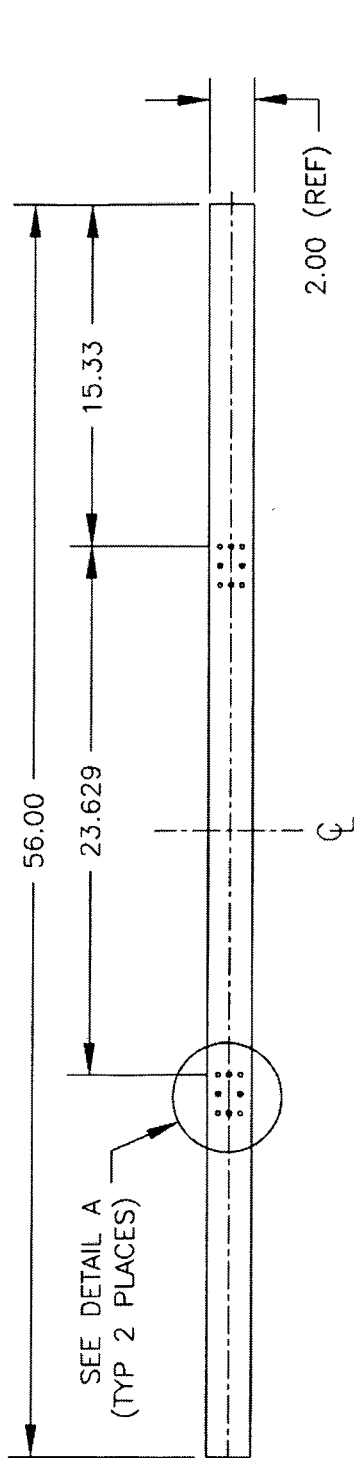


W/O 53220



DESIGN UP	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3173	REV. B SHEET 3 OF 3
DATE 03.01.07		TITLE BEAM ASSEMBLY	SCALE 1:8

### D3173-1 BEAM



DETAIL A  
SCALE 1:2

RELEASED  
03.01.10

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